

Date: Friday, 5/25/2007 8:01:38 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM
Job Number	: 32550		
Estimate Number	: 10706		
P.O. Number	: N/A	Part Number	: D2012103
This Issue	: 5/25/2007 S.O. No. : N/A	Drawing Number	: D2012-103 REV B2
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: B2
Previous Run	: 31482	Material	: N/A
Written By	:	Due Date	: 6/6/2007
Checked & Approved By	: <u>07.05.28</u>	Qty:	5 Um: Each
Comment	: Est Rev: 02.04.03 Added Inspect level 3 NG		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0500W035	304 RD Tube .500 x .035W
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Comment: Qty.: 3.5700 f(s)/Unit Total : 17.8500 f(s)  
 Material: 304/316 Seamless SS tubing, 1/2" O.D. x .035" wall(M304TR0.500W.035)  
 Identify as D2012-101  
 Batch: 17104640

FF 07-06-26 5

2.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

~~REWORK~~ as per Dwg D2012-103 & template D2012-103T1(41.00")

FF 07-06-26 3

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1-Debur

2-Bend D2012-103 as per template D2012-103T2 &amp; Dwg D2012-103

FF 07-06-27 5

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

En 07.06.28

(cont'd)  
(X5)

5.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

BF/mj/07-06-28

(5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ \_\_\_\_\_ Date: 07/06/29

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:01:38 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 32550

Part Number: D2012103

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7/6/29 SP (5)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 51230

7/6/29 SP (5)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(5)  
7/6/29

Job Completion



W 7-06-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

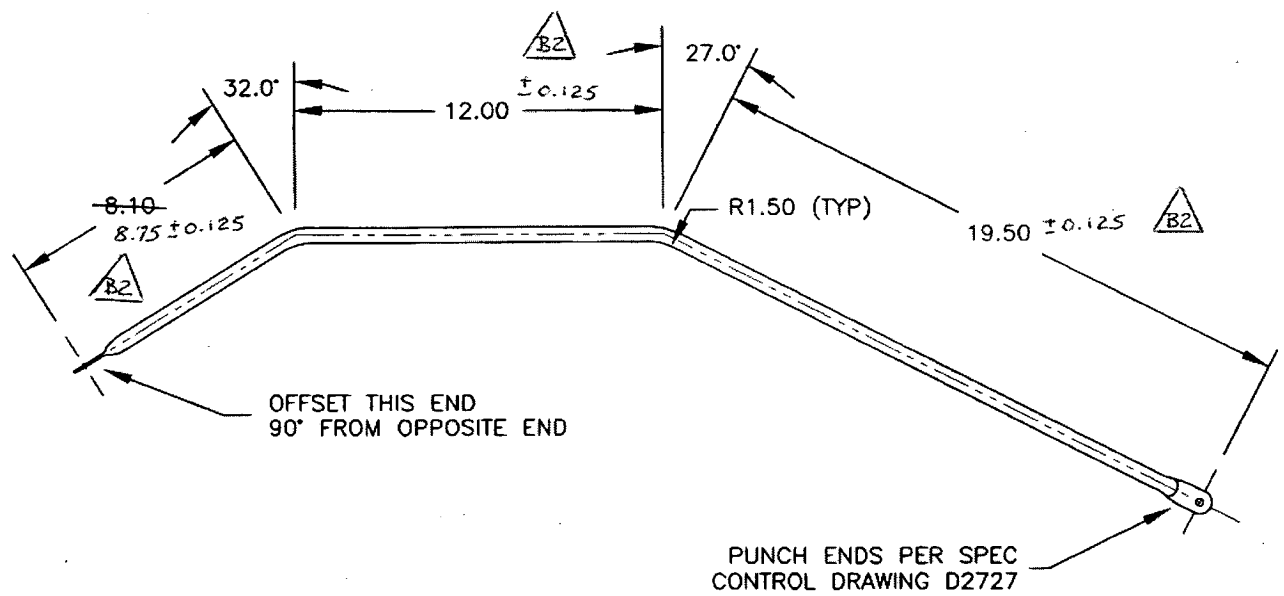
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED  
94/05/05 KG

DESIGN		DRAWN BY		DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED KE		APPROVED KE		DRAWING NO. D2012-103	
DATE 98.04.28		TITLE ARM		REV. B SHEET 1 OF 1	
A		92.06.08		NEW ISSUE	
B		98.04.28		CHANGE ANGLES (TSR A362)	
B1		02.05.25		ADD FINISH	
B2		05.04.27		ADD TOLERANCE, 8.75 WAS 8.10	



NOTES:

1. MAKE PER TEMPLATE DT8068 (WAS DT2012-103)
2. MATERIAL: AISI 304/316 STAINLESS STEEL TUBE Ø0.500 x 0.035 WALL
3. FINISH: POWDER COAT BLACK SANDTEX (4,3,5,7) PER DART Q51005 4.3 B1

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 32550